DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027878
Date Inspected: 01-Jul-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job Site

CWI Name:	As noted below			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG

Summary of Items Observed:

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

12E-E2.1 (Exterior)

This QA Inspector at random intervals, observed ABF/JV certified welders Rory Hogan #3186 performing Submerged Arc Welding (SAW) by operating a Lincoln track mounted wire feeder on y+29,000mm to y+14, 000mm of 12E-E2.1 and James Zhen #6001 at 14,000mm to y+1000mm. This QA Inspector observed heat induction blankets to provide pre-heat for the single bevel joint and verified the temperature was the required minimum of 150° F. It was also noted that the remote oven for the ESAB EN 760 Flux was in the on position with the dial set at 250° F. This QA Inspector verified that the prior electrode spool was discarded and replaced with a new F7A2-EM12KH8 electrode spool. QC Inspector Fred Michels measured the parameters for amperage, volts, travel speed and the heat input as the welder adjusted the controls on the wire feeder. On a subsequent observation, this QA Inspector observed ABF welding personnel recycle the flux utilizing a vacuum hose and cleaning the edge of the work with a chipping hammer between passes. The welders were observed adjusting the path of the feeder prior to each consecutive pass during the ongoing process and inspected each completed pass for indications and workmanship. QC was present to monitor the welding and the parameters so they remain within the requirements of WPS-D1.5-4042B-1. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general conformance with the contract specifications.

12E Corner Drop-In Panel (Interior)

This QA Inspector randomly conducted fit up and measurement of the 12E Corner Drop-In Panel on the interior of the OBG. QC Inspector Salvador Merino utilized a Bridge Cam gauge to measure the planar offset of the 12E-E2. 1-C1 seam located on Side Plate “C”, and 12E/13E –B1, on Edge Plate “B” on the exterior of the OBG. The work at this location is in progress and appeared to be in general conformance with the contract specifications.

Summary of Conversations:

This QA Inspector discussed the offset of 12E-E2.1-C with Quality Control Inspector Salvador Merino.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer